

86223

Monday, June 25, 2012 8:52:29 AM

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 6/25/2012 **Start Qty:** 5.00 ***5***

Required Date: 7/2/2012 **Req'd Qty:** 5.00 ***5***

Customer:

Reference: REWORK TO REV D

Approvals: Process Plan: mf Date: 12-06-25 Tooling:

Date:

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 Mill Conv	Memo	0.00							
Conventional Milling Machine	REWORK PARTS TO REV D DRAWING	0.00	D.	12-06-26		5	0		
200 QC	Memo	0.00							
Quality Control	QC2- Inspect parts off machine FAI/FAIB	0.00	D.	12-06-26		5	0		
210 QC	Memo	0.00							
Quality Control	QC8- Inspect parts - second check	0.00	B.A	12/06/26		5	0		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 86223

Monday, June 25, 2012 8:52:29 AM

86223

Page 2

Item ID: D3695-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Slider

Start Date: 6/25/2012 Start Qty: 5.00

5

Cust Item ID:

Required Date: 7/2/2012 Req'd Qty: 5.00

5

Customer:

Reference: REWORK TO REV D

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

220

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

220

Powdercoat

Memo

0.00

Powder Coating

TOUCH UP WITH ALODINE IF NECESSARY

TOUCH UP WITH GREY POWDERCOAT IF NECESSARY

5706 12-6-27

230

QC7-Inspect Chemical Conversion Coat

0.00

230

QC

Memo

0.00

Quality Control

54 BL 12-6-27

240

Identify as per dwg & Stock Location: 255

0.00

240

Packaging

Memo

0.00

Packaging

ID AND STOCK UNDER NEW BATCH NUMBER

5 12/06/27JB

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Page 3

Item ID: D3695-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Slider

Stop ***NS2***

Start Date: 6/25/2012 Start Qty: 5.00

5

Cust Item ID:

Required Date: 7/2/2012 Req'd Qty: 5.00

5

Customer:

Reference: REWORK TO REV D

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

250

QC21- Final Inspection - Work Order Release

0.00

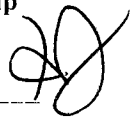
250

QC

Memo

0.00

Quality Control

12/6/28 MF
12-06-27

W/O:		WORK ORDER CHANGES					
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Picklist Print

Monday, June 25, 2012 8:52:29 AM

Page 1

Work Order ID: 86223

Parent Item: D3695-1

Parent Item Name: Slider

Start Date: 6/25/2012

Required Date: 7/2/2012

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP Rev:A 08-03-27 new issue DD verified by:JLM IPP rev B 10.02.03 as per ncr
10-015 EC verified by: JLM IPP rev:C 10.11.29 as per dwg revD DD verf:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3695-1 Slider		Manufactured	No				Each	0.0000		5			

5 x ~~85071A~~
56868
MF
12-06-25.

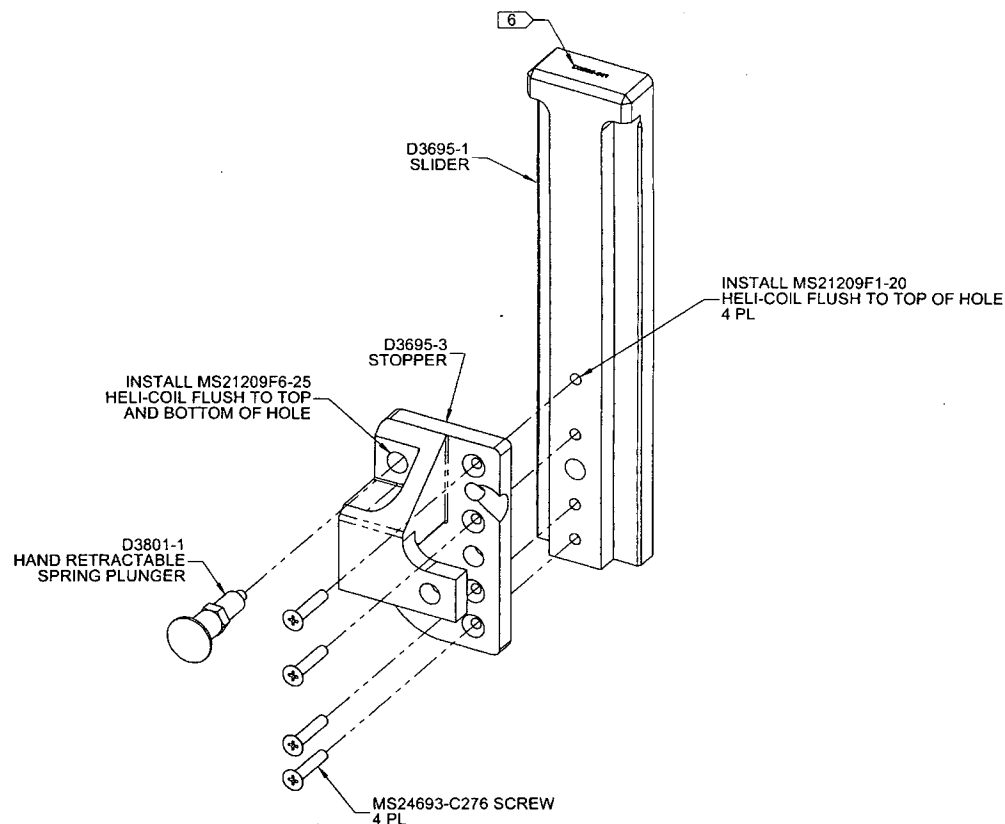
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D3695-041 SLIDER ASSEMBLY

D3695-041 NOTES:

- 1) MATERIAL: NONE
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENT P/N "D3695-041" PER QSI 044 6.1
- 7) WEIGHT: D3695-041 = 0.63 lbs

ITEM	QTY -041	P/N	DESCRIPTION
1	X	D3695-041	SLIDER ASSEMBLY
11	1	D3695-1	SLIDER
12	1	D3695-3	STOPPER
15	1	D3801-1	HAND RETRACTABLE SPRING PLUNGER
21	4	MS21209F1-20	HELI-COIL, SCREW LOCKING (RED)
22	1	MS21209F6-25	HELI-COIL, SCREW LOCKING (RED)
23	4	MS24693-C276	SCREW

D	NOTE 6 UPDATED PER QSI. DIM 0.994 ^{+0.000} / _{-0.010} WAS 1.000 ^{+0.000} / _{-0.010} & 0.503 WAS 0.500 (ZN C6-2). REF NCR 10-324. CHAMFER ADDED TO D3695-1 (ZN C5-2)	JPH	10.09.24
C	UPDATED BOM TO CURRENT STANDARDS; REVISED ITEM 12 (ZN D3-1); DIMS 1.83 AND 1.075 ^{+0.005} / _{-0.005} WERE 1.81 AND 1.063 ^{+0.005} / _{-0.005} (ZN B8-3 AND C4-3). REASON: COMPENSATE FOR PAINT THICKNESS AND ELIMINATE RATTLE UPON ASSEMBLY.	MB	08.11.04
B	P/N D3808-1 WAS WIP-510 (ZN C7-1 AND D3-1). REASON: PURCHASED PARTS NOW PROCURED THROUGH D3801 SPEC CONTROL DRAWING	MB	08.06.26
A	NEW ISSUE	MB	08.03.14
REV.	DESCRIPTION	BY	DATE
DESIGN	JPH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	JPH	DRAWING NO.	REV. D
MFG. APPR.	JPH	D3695	SHEET 1 OF 3
APPROVED	JPH	TITLE	SCALE
DE APPR.	JPH	SLIDER ASSEMBLY	NTS
DATE	10.09.24	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

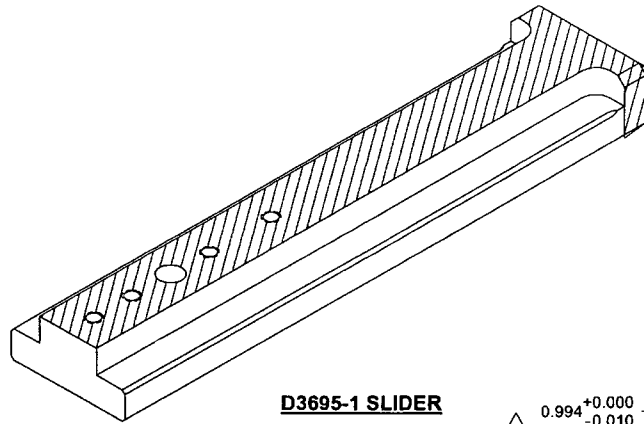
W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

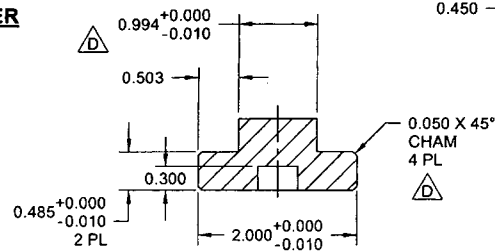
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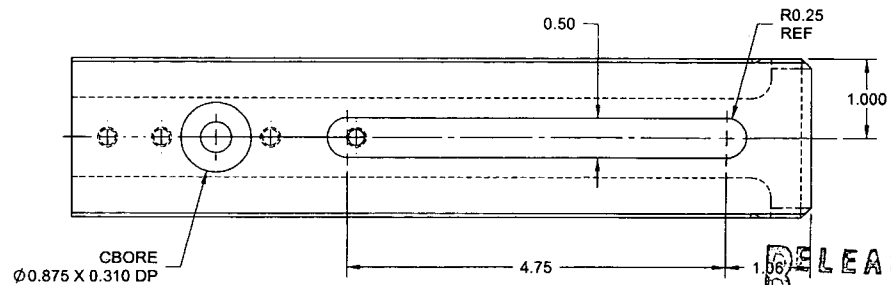
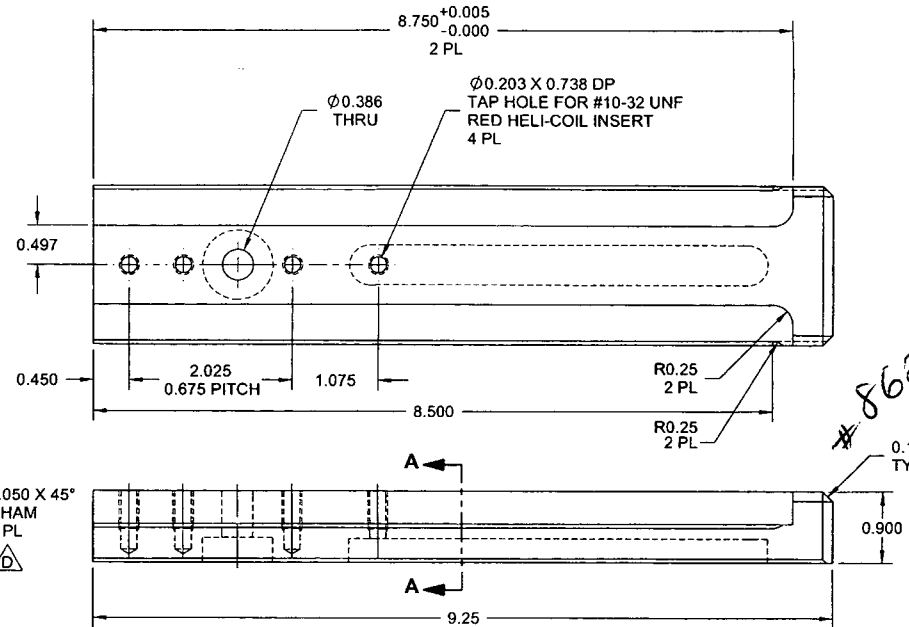
NOTE: Date & initial all entries



D3695-1 SLIDER



SECTION A-A



D3695-1 NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/-T6510/-T6511/-T62) BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
PER AMS-QQ-A-200/8 (OR AMS 4160)
(REF. DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART
QSI 005 4.3 - MASK ALL HOLES AND UNHATCHED AREAS
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.43lbs

DESIGN	JPH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D3695	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		SLIDER ASSEMBLY	NTS
DATE	10.09.24	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR LOANED OR COMMERCIALIZED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

RELEASED
2010-11-25

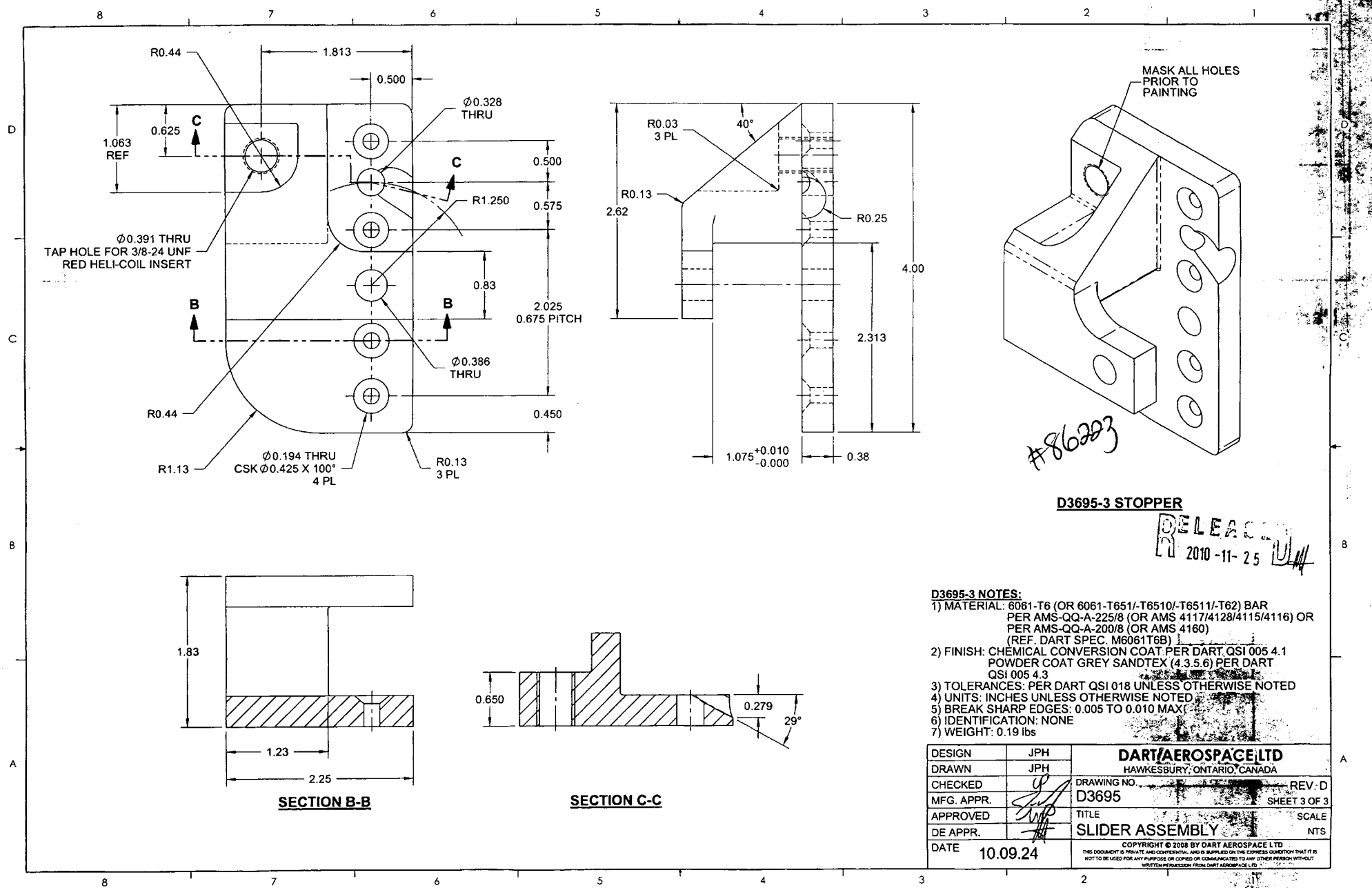
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NOTE: Date & initial all entries



D3695-3 STOPPER

RELEASED
2010-11-25

D3695-3 NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
PER AMS-QQ-A-200/8 (OR AMS 4160)
(REF. DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANTEX (4.3.5.6) PER DART
QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.19 lbs

DESIGN	JPH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	JPH	DRAWING NO.	REV. D
MFG. APPR.	JPH	D3695	SHEET 3 OF 3
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DE APPR.	JPH	SLIDER ASSEMBLY	NTS
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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